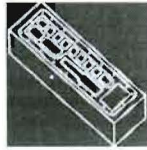


AUTOMATED MANUFACTURING TECHNOLOGY



PURPOSE

To evaluate each contestant's preparation for employment in automated manufacturing and the team approach to problem solving work environment. To recognize outstanding students for excellence and professionalism in the field of automated manufacturing technology.

First, refer to General Regulations, Page 9.

CLOTHING REQUIREMENT

Official khaki work shirt and pants, black or brown leather work shoes, and safety glasses with side shields or goggles. (Prescription glasses can be used only if they are equipped with side shields. If not, they must be covered with goggles.) To purchase official work clothes, contact Midwest Trophy Manufacturing Co. Inc. by calling 800-324-5996 or order online at www.mtmrecognition.com/skillsusa/.

Note: Contestants must wear their official contest clothing to the contest orientation meeting.

ELIGIBILITY

Open to active SkillsUSA members enrolled in programs with precision machining, automated manufacturing, or CAD/CAM or CNC as the occupational objective.

EQUIPMENT AND MATERIALS

1. Supplied by the technical committee:
 - a. CNC machining center with:
 1. Machinist vise
 2. Hold-downs and clamps
 3. Tool holders
 4. End mills
 - b. Part(s) design
 - c. Competition notebook
 - d. Pencils
 - e. Blank diskettes or USB thumb drives
 - f. Material for machining
2. Supplied by the contestants:
 - a. One-page, typewritten résumé
 - b. Two computers:
 1. One computer loaded with CAD software for CAD program

2. One computer loaded with software for CAM program. This computer **MUST** have an open full-sized PCI slot and Windows 98 or higher operating system.
- c. Licensed versions of the above CAD and CAM software **MUST** be available at start of the orientation/practice session on Tuesday for loading onto the technical committee's computer(s).
- d. One 6" dial or digital vernier caliper
- e. One dial indicator. Dial indicator must have 3/8" or 1/2" holding shank to fit into tool holder supplied by the technical committee.
- f. One calculator
- g. One pair of 3/4" or 1" parallels
- h. One soft-face hammer
- i. One 6" or 12" steel rule

Note: Only the above listed items will be allowed in the contest area during the competition.

SCOPE OF THE CONTEST

The contest will test the ability to perform, exhibit and compile skills and knowledge from the following list of competencies determined by the SkillsUSA Automated Manufacturing Technology technical committee. Committee membership includes Intelitek Inc., C&S Hobbies, CNC Software, DEPCO Inc., Learning Labs Inc., National Tooling & Machining Association and Technical Education Solutions LLC.

Knowledge Performance

The contest includes a written knowledge test assessing general knowledge related to automated manufacturing technology. Written portions may also exist during the skills portion of the contest. The exam is an evaluation that measures ability to solve various solutions to the process that is involved in quoting a job in a rapid prototyping environment.

Skill Performance

The contest includes a team skill performance for three students and evaluates teams for employment in integrated manufacturing technology fields of computer aided drafting/design (CAD), computer aided manufacturing (CAM), and computer numerical controlled machining (CNC).

Contest Guidelines

1. All equipment provided by the technical committee will be in place and set up on the Monday before the competition begins. On the Tuesday before the competition, there

will be an orientation/practice for all teams. Teams must bring their computers and above-listed equipment to the orientation on Tuesday. Teams will not be allowed to remove their computers from the competition area until after 3 p.m. on Thursday.

2. During the orientation, teams will be divided into two groups. Group One will practice on Tuesday morning and compete on Thursday. Group Two will practice on Tuesday afternoon and compete on Wednesday. Team advisors are strongly encouraged to be with their team during the orientation and practice.
3. All team members and advisors are required to attend a debriefing session on Friday morning.
4. Teams must be composed of three members.
5. The teams will be presented with dimensioned drawing(s) of a part(s) to prototype during the contest.
6. The CAD operators construct the part geometry; the CAM operator generates the tool paths; and the CNC operator sets up and machines the part. When a team member has spare time, he or she will help others in the group.
7. One person should not dominate a team by doing the CAD drawing, the CAM toolpath, and running the CNC machine while using the other members simply as support. The contest is designed to promote creativity in organization of production responsibility.
8. All group members are responsible for double-checking each other's work and quality control.
9. When the teams finish machining the prototype part(s), they will present it to the client (judges). At this time, they will be presented with a second drawing(s) as either a change order or as an additional part(s).
10. Each team will be issued a notebook. This will be a three-ring view binder. Included in the binder will be all the necessary information and forms to complete the project. These forms will not be highly specific but will coach the teams.
11. All binders, forms and drawings must be turned in to the judges at the end of the competition.

Standards and Competencies

MFG 1.0 — Perform mathematical and measurement calculations used in automated manufacturing situations

- 1.1 Measure work pieces to the nearest .001 inch
- 1.2 Calculate CNC speed and feeds

- 1.3 Calculate stock utilization and setup
- 1.4 Calculate tolerances
- 1.5 Calculate various variables to estimate costs and material usage written evaluation

MFG 2.0 — Design, sketch and plan machine work to U.S. National CAD Standards

- 2.1 Transfer information from provided drawing to CAD drawing
- 2.2 Create CAD file for manufacturing using standard CAD terminology and standard practice
- 2.3 Initiate manufacturing documentation process
- 2.4 Generate a process plan
- 2.5 Plot a CAD file
- 2.6 Export a CAD file
- 2.7 Process Engineering Change Orders (ECO)
- 2.8 Repeat steps as necessary to accommodate ECO

MFG 3.0 — Create a toolpath (CAM file) and the CNC code to related duty tasks of the National Institute for Metalworking Skills (NIMS) Duties and Standards for Machining Skills, Level I

- 3.1 Create process plan (job plan)
- 3.2 Read-in CAD export file
- 3.3 Create toolpath
- 3.4 Verify toolpath
- 3.5 Create CNC code
- 3.6 Send CNC code to machine tool
- 3.7 Process Engineering Change Orders (ECO)
- 3.8 Repeat steps as necessary to accommodate ECO

MFG 4.0 — Perform CNC machining functions given a scenario to the related duty tasks of the National Institute for Metalworking Skills (NIMS) Duties and Standards for Machining Skills, Level I

- 4.1 Verify CNC file existence
- 4.2 Verify toolpath
- 4.3 Set up fixture(s) and tooling on machine
- 4.4 Set up part(s) on mill
- 4.5 Set all offsets and tooling
- 4.6 Adjust machine speeds and feeds as needed
- 4.7 Complete an in-process quality assurance process
- 4.8 Perform tool changes
- 4.9 Perform multiple machining operations in one setup
- 4.10 Demonstrate proficiency in using a CNC machine tool and produce part(s)
- 4.11 Use Total Quality Management practices to verify process and part
- 4.12 Process Engineering Change Orders (ECO)
- 4.13 Repeat steps as necessary to accommodate ECO

MFG 5.0 — Perform and inspect part(s) using a Total Quality Management process

- 5.1 Verify part(s) to provided standards
- 5.2 Verify part(s) to ECO standards
- 5.3 Document process of verification and inspection

MFG 6.0 — Demonstrate safety practices in a working situation to the related duty tasks of the National Institute for Metalworking Skills (NIMS) Duties and Standards for Machining Skills-Level I

- 6.1 Carry out assigned responsibilities while adhering to safe practices in accordance with OSHA requirements and guidelines
- 6.2 Document safety activities as require
- 6.3 Demonstrate safety procedures in running and programming a CNC machine tool

MFG 7.0 — Provide an accurate quotation given an automated manufacturing technology simulated scenario

- 7.1 Solve various solutions to the process that is involved in quoting a job in a rapid prototyping environment

Committee Identified Academic Skills

The technical committee has identified that the following academic skills are embedded in this contest.

Math Skills

- Use fractions to solve practical problems
- Use proportions and ratios to solve practical problems
- Use scientific notation
- Solve single variable algebraic expressions
- Solve multiple variable algebraic expressions
- Measure angles
- Find surface area and perimeter of two-dimensional objects
- Find volume and surface area of three dimensional-objects
- Construct three-dimensional models
- Apply Pythagorean Theorem
- Solve problems using proportions, formulas and functions
- Find slope of a line
- Solve practical problems involving complementary, supplementary and congruent angles
- Solve problems involving symmetry and transformation

Science Skills

- Use knowledge of physical properties (shape, density, solubility, odor, melting point, boiling point, color)

Language Arts Skills

- Provide information in conversations and in group discussions
- Demonstrate comprehension of a variety of informational texts
- Organize and synthesize information for use in written and oral presentations
- Demonstrate knowledge of appropriate reference materials

Connections to National Standards

State-level academic curriculum specialists identified the following connections to national academic standards.

Math standards

- Numbers and Operations
- Geometry
- Measurement
- Data Analysis and Probability
- Problem Solving
- Communication
- Connections
- Representation

Source: NCTM Principles and Standards for School Mathematics. To view high school standards, visit: standards.nctm.org/document/chapter7/index.htm. Select "Standards" from menu.

Science Standards

- Understands the structure and properties of matter
- Understands the sources and properties of energy
- Understands the nature of scientific inquiry

Source: McREL compendium of national science standards. To view and search the compendium, visit: www.mcrel.org/standards-benchmarks/.

Language Arts Standards

- Students apply a wide range of strategies to comprehend, interpret, evaluate and appreciate texts. They draw on their prior experience, their interactions with other readers and writers, their knowledge of word meaning and of other texts, their word identification strategies, and their understanding of textual features (e.g., sound-letter correspondence, sentence structure, context, graphics)

- Students adjust their use of spoken, written, and visual language (e.g., conventions, style, vocabulary) to communicate effectively with a variety of audiences and for different purposes
- Students apply knowledge of language structure, language conventions (e.g., spelling and punctuation), media techniques, figurative language and genre to create, critique, and discuss print and nonprint texts
- Students use a variety of technological and information resources (e.g., libraries, databases, computer networks, video) to gather and synthesize information and to create and communicate knowledge
- Students participate as knowledgeable, reflective, creative and critical members of a variety of literacy communities
- Students use spoken, written and visual language to accomplish their own purposes (e.g., for learning, enjoyment, persuasion, and the exchange of information)

Source: IRANCTE Standards for the English Language Arts. To view the standards, visit:
www.readwritethink.org/standards/index.html.

CONTEST SCORECARD

Items Evaluated	Possible Points
PROTO-CAD Eval Dim Drawing	170
PROTO-CAD Contest Drawing	25
PROTO-CAM Process Plan Form	100
PROTO-CNC Fixture Desc. Form.....	100
PROTO-CNC Quality Assurance	50
PROTO-CNC Surface Finish Accuracy	150
PROTO-CNC Hand in time	100
CONC ENG-CAD Change Order Drawing.....	25
CONC ENG-CAM Process Plan	10
CONC ENG-CAD Eval Dim Drawing	70
CONC ENG –Surface Fin-Dim Accuracy.....	100
Math Problem.....	100

Sub Total	1,000
Résumé Penalty	_____
Clothing Penalty	_____
Safety Penalty	_____
TOTAL	_____